

Work Order ID 125614 - 2

Thursday, October 16, 2014 2:20:40 PM

125614

Page 1

SPLIT

SHAP Mon Oct 27

Item ID: D4941-1L08

Accept

N900040100

Setup

Start

NS1

Revision ID:

(1)

Stop

NS2

Item Name: Floor Protector, Fwd LH, (Clear)

Start Date: 10/17/14 Start Qty: 5.00

5

Cust Item ID:

Required Date: 10/24/14 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

(Signature)

Date: 14-10-16

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4941

D

100

0.00

100

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

(S)

DAS

27

9-09

4/10/16

105

0.00

105

Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

(S)

DAS

27

9-09

4/10/16

Temp:

245 deg. F

Time IN:

5:00 PM

Time OUT:

6:00 AM

OCT 15 2014

Per.....

Work Order ID 125614

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Page 2

Item ID: D4941-1L08 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Floor Protector, Fwd LH, (Clear)
 Start Date: 10/17/14 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 10/24/14 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* Thermoform Thermoforming Machine	THERMOFORMING MACHINE Memo Thermoform as per Dwg. D4941 and Folio FTA 158 Dwg. Rev. <u> P </u> Folio Rev. <u> C </u>	0.00 0.00				<u> N/K </u>	<u> 16 </u>	DAS 27 9-29	
130 *130* Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Trim to Finished Dimensions	0.00 0.00				<u> X </u>			DAS 07 9-29 17/10/23
140 *140* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				<u> X </u>			DAS 07 9-29 17/10/27

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Page 3

Item ID: D4941-1L08

Revision ID:

Item Name: Floor Protector, Fwd LH, (Clear)

Start Date: 10/17/14 Start Qty: 5.00

Required Date: 10/24/14 Req'd Qty: 5.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

① 14-10-27 PD

160

Packaging

0.00

160

Packaging

Memo

0.00

Packaging

APP/24924

QAS
Q3
9-89

OCT 28 2014

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

14/10/28 JF

mf
14-10-28

Picklist Print

Thursday, October 16, 2014 2:20:44 PM

Page 1

Work Order ID: 125614

125614

Parent Item: D4941-1L08

D4941-1L08

Parent Item Name: Floor Protector, Fwd LH, (Clear)

Start Date: 10/17/14

Required Date: 10/24/14

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev. A New Issue 13/12/16 DL
Revised dimensions 14/02/12 DL
14/07/02 DL

IPP Rev. B
IPP Rev C Revised Dwg.
IPP Rev D Revised Dwg. 14/07/25 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.118-90318-08

Purchased

No

100

sf

2,251.508

4.875

25

DAE

27

9.89

MI FXS 118-90318-08

Lexan Sheet

Location

Loc Qty

Loc Code

therm

2251.508

113127

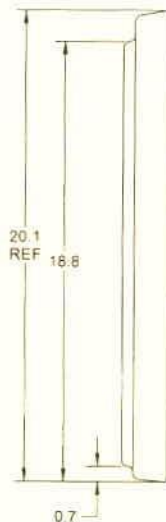
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m126994

2243.508

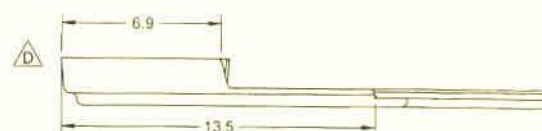
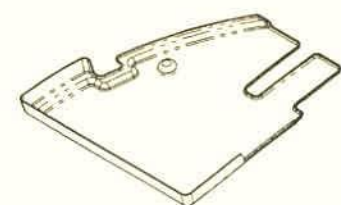
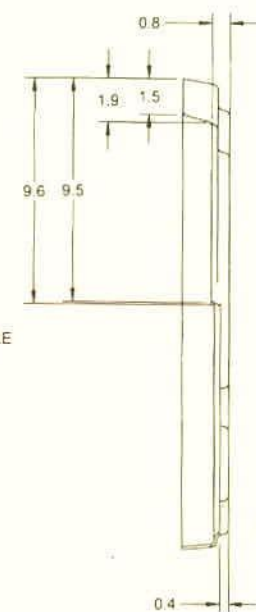
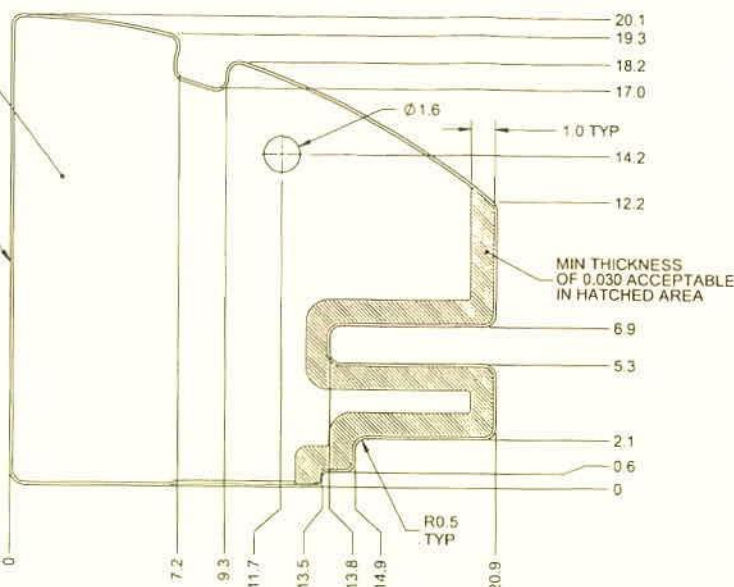
4/10/16

25



TEXTURED SURFACE
ON THIS SIDE

5



D4941-1LXX FWD LH FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 1.5 lbs
- 8) THERMOFORM PER QSI 022 USING MOLD DT9990 TRIM PER MOLD LEAVING FINISHED EDGES
- 9) MINIMUM THICKNESS AFTER FORMING IS 0.070"

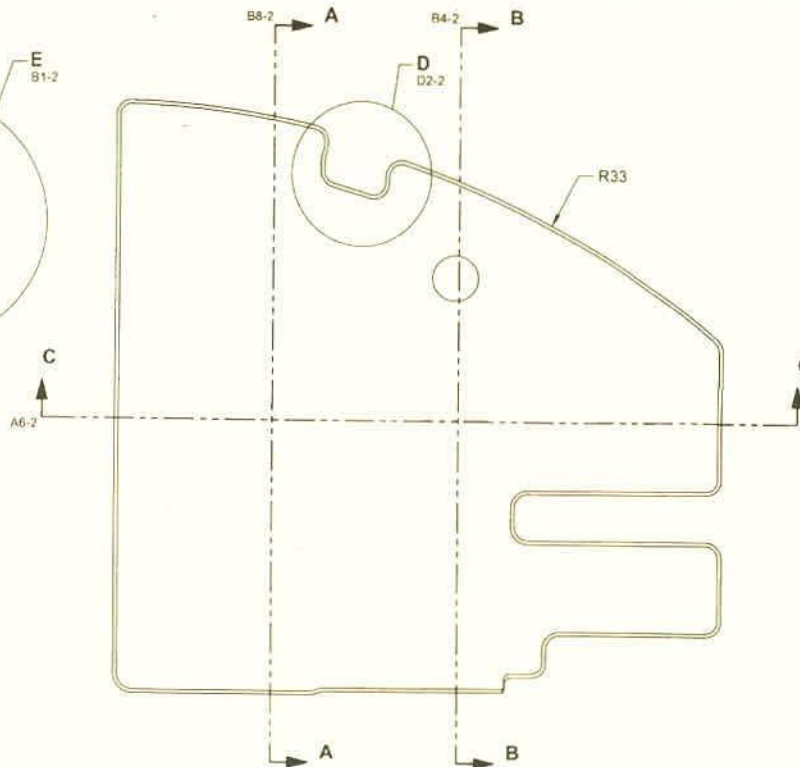
Handwritten: 14-10-18 125614

PART NUMBER	DESCRIPTION
D4941-1L02	F6006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.125 THICK (REF DART SPEC MLEXS 125-F6006-02)
D4941-1L08	90318 PROTECT-A-GLAZE 112 CLEAR LEXAN SHEET 0.118 THICK (REF DART SPEC MLEXS 118-90318-08)

APPROVED

D	ADDED VIEWS (ZN C3-1, ZN D6-1, ZN A6-1), EDITED DETAIL D (ZN D2-2) AND DETAIL F (ZN B3-2), EDITED TRIM LOCATION ON D4941-2 (ZN B6-3), EDITED VIEW (ZN D6-3) ADDED VIEW (ZN A6-3), ADDED DETAIL H (ZN C2-3) REVISED D4941-3 AND D4941-4	AK	14.07.25
C	EDITED TRIM LOCATION ON D4941-1 (ZN D8-2, ZN D6-2, ZN A6-2, ZN D2-2, ZN C1-2), ADDED A CUTOUT TO D4941-2LXX (ZN B6-3) REVISED D4941-4 TO REMOVE CUTOUT (ZN B8-5)	AK	14.06.16
B	REVISED OVERALL DIMENSIONS OF D4941-1/-2/-3/-4	AK	14.02.12
A	NEW ISSUE	AK	13.10.03
REV	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO	REV D
MFG. APPR	DL	D4941	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR	DS	CABIN FLOOR PROTECTORS	NTS
DATE	14.07.25	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

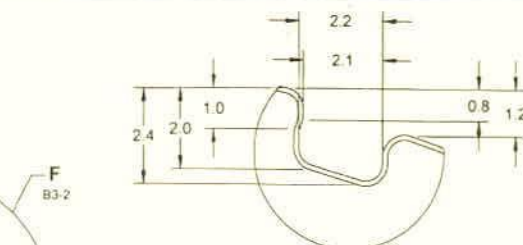
SECTION A-A
D6-2



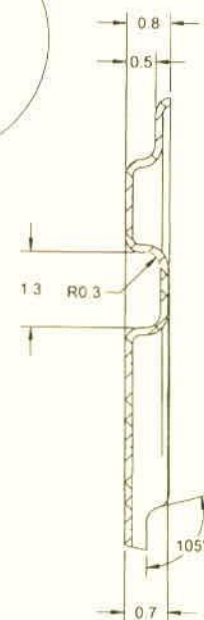
SECTION C-C
C6-2

SECTION B-B
D5-2

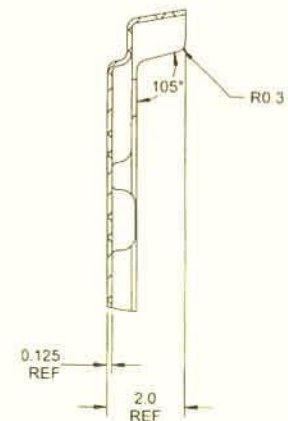
DETAIL D
D6-2



DETAIL F
D4-2



DETAIL E
D8-2



D4941-1LXX FWD LH FLOOR PROTECTOR

APPROVED

DESIGN	AK
DRAWN	AK
CHECKED	VS
MFG APPR	DL
APPROVED	HS
DE APPR	DS
DATE	14.07.25

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4941** REV. D
SHEET 2 OF 5
TITLE **CABIN FLOOR PROTECTORS** SCALE NTS

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